

US012057738B2

(12) **United States Patent**
Morgante et al.

(10) **Patent No.:** **US 12,057,738 B2**
(45) **Date of Patent:** ***Aug. 6, 2024**

(54) **ELECTRIC MOTOR AND STATOR COOLING APPARATUS**

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

This patent is subject to a terminal disclaimer.

(21) Appl. No.: **18/092,227**

(22) Filed: **Dec. 31, 2022**

(65) **Prior Publication Data**
US 2023/0134328 A1 May 4, 2023

Related U.S. Application Data

(63) Continuation of application No. 17/128,281, filed on Dec. 21, 2020, now Pat. No. 11,569,698, which is a (Continued)

(51) **Int. Cl.**
H02K 1/20 (2006.01)
H02K 3/24 (2006.01)
(Continued)

(52) **U.S. Cl.**
CPC **H02K 1/20** (2013.01); **H02K 3/24** (2013.01); **H02K 5/203** (2021.01); **H02K 9/19** (2013.01); **H02K 9/197** (2013.01)

(58) **Field of Classification Search**
CPC H02K 1/20; H02K 3/24; H02K 5/203; H02K 9/19; H02K 9/197; H02K 5/04;
(Continued)

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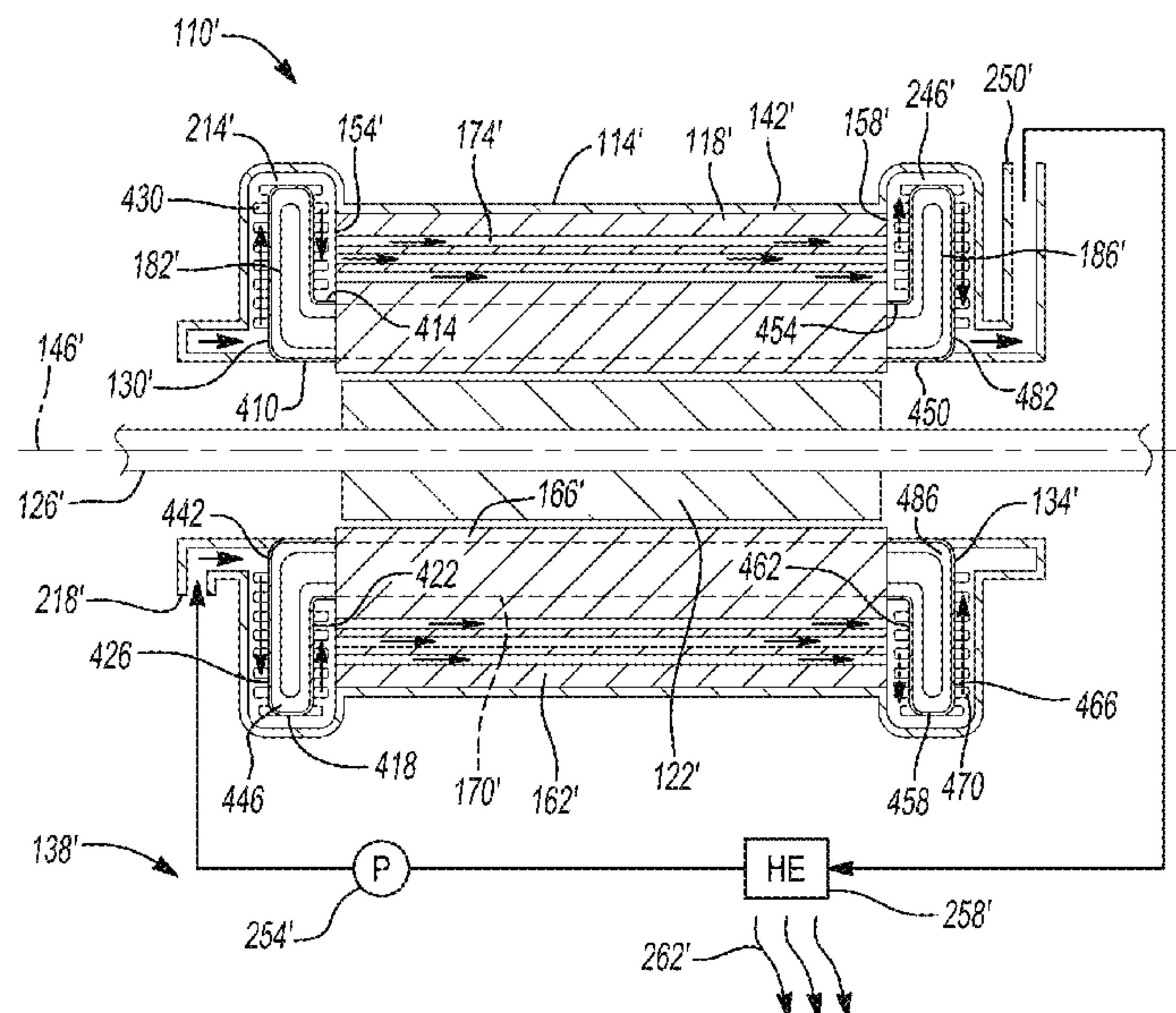
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(57) **ABSTRACT**

An electric motor can include a stator body defining fluid channels extending axially for fluid communication between axial ends of the stator body. Conductive windings can form first loops extending axially outward from the first end of the stator body and second loops extending axially outward from the second end of the stator body. A first cap can be coupled to the first end of the stator body and can include a first wall. The first wall can be between the first loops and the channels. Pins can extend from a side of the first wall that is opposite the first loops. The second cap can be coupled to the second end of the stator body and include a second wall. The second wall can be between the second loops and the channels. Pins can extend from a side of the second wall that is opposite the second loops.

20 Claims, 5 Drawing Sheets



Related U.S. Application Data

continuation of application No. 15/820,934, filed on
Nov. 22, 2017, now Pat. No. 10,879,749.

(51) **Int. Cl.**

H02K 5/20 (2006.01)
H02K 9/19 (2006.01)
H02K 9/197 (2006.01)

(58) **Field of Classification Search**

CPC . H02K 11/25; H02K 3/14; H02K 5/18; H02K
2205/09; H02K 9/22; B60K 2001/006
USPC 310/54
See application file for complete search history.

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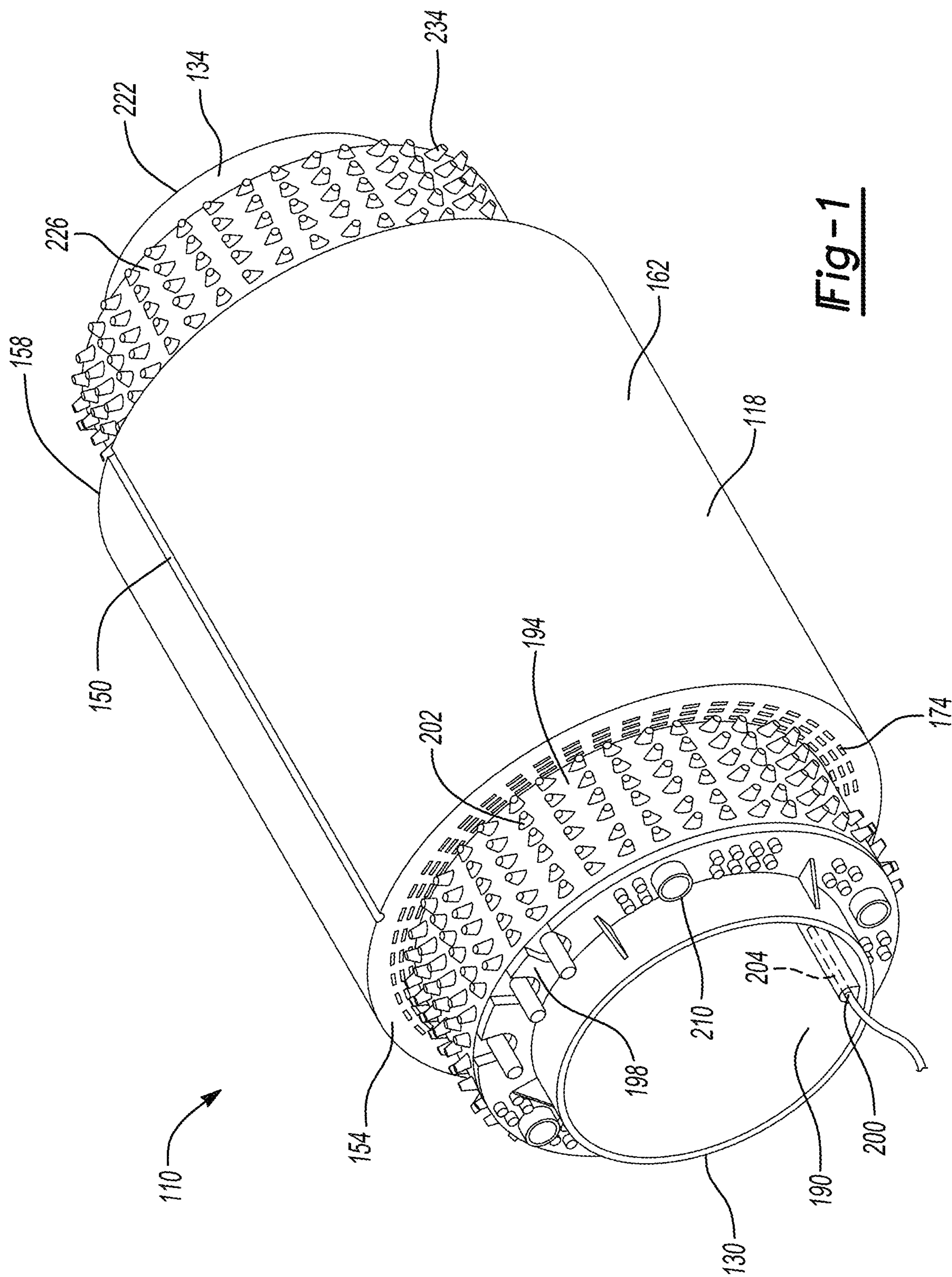


Fig-1

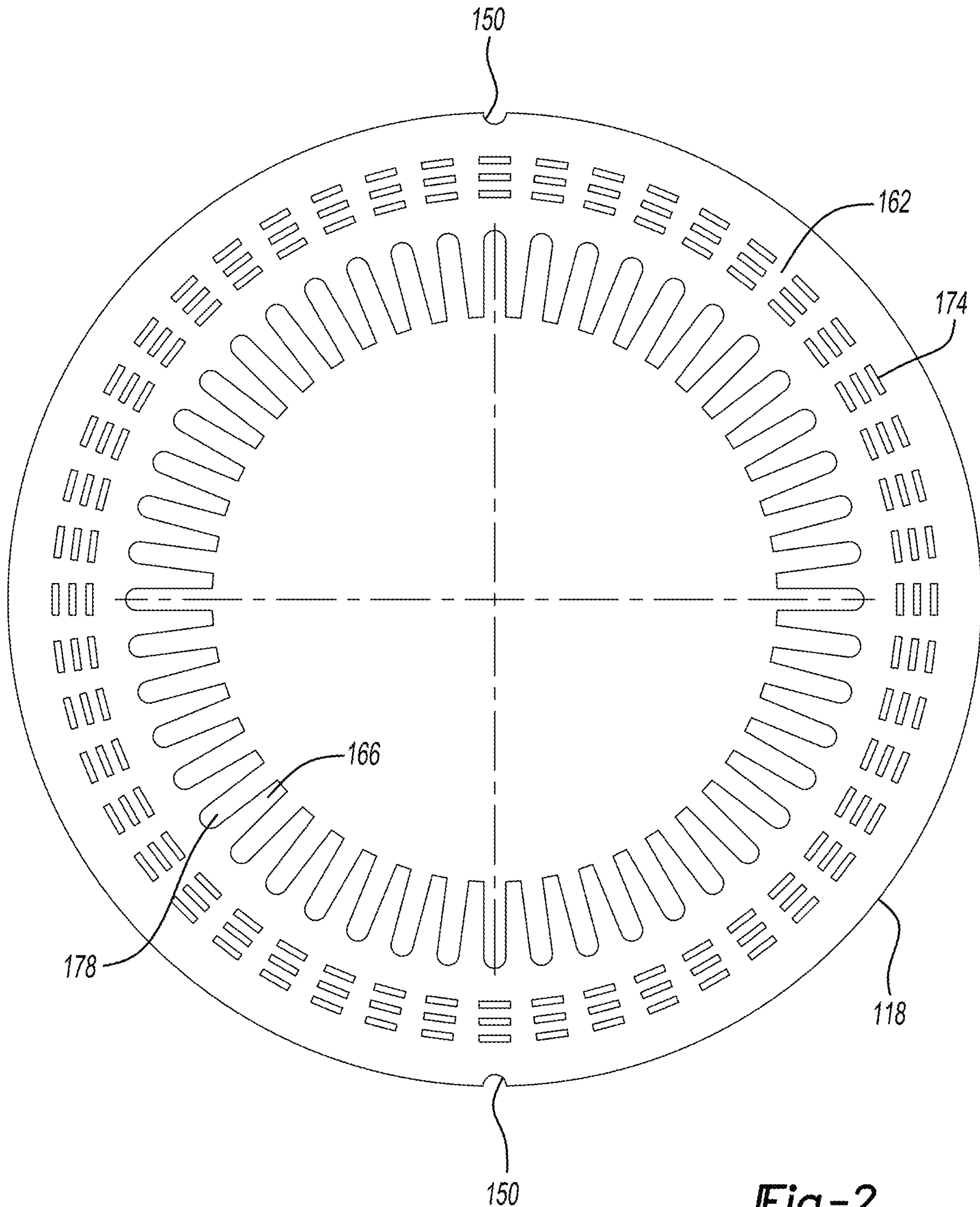


Fig-2

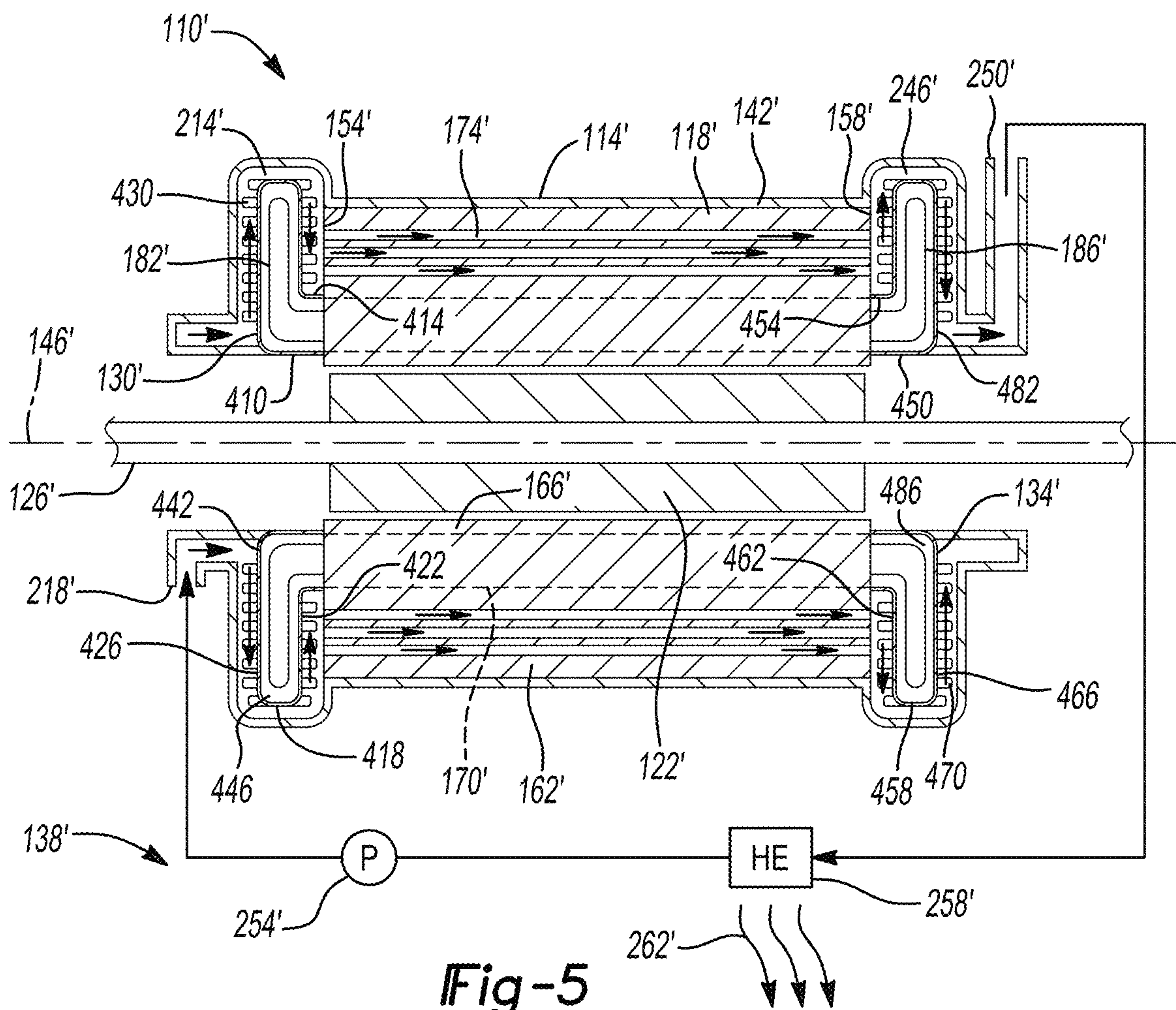


Fig-5

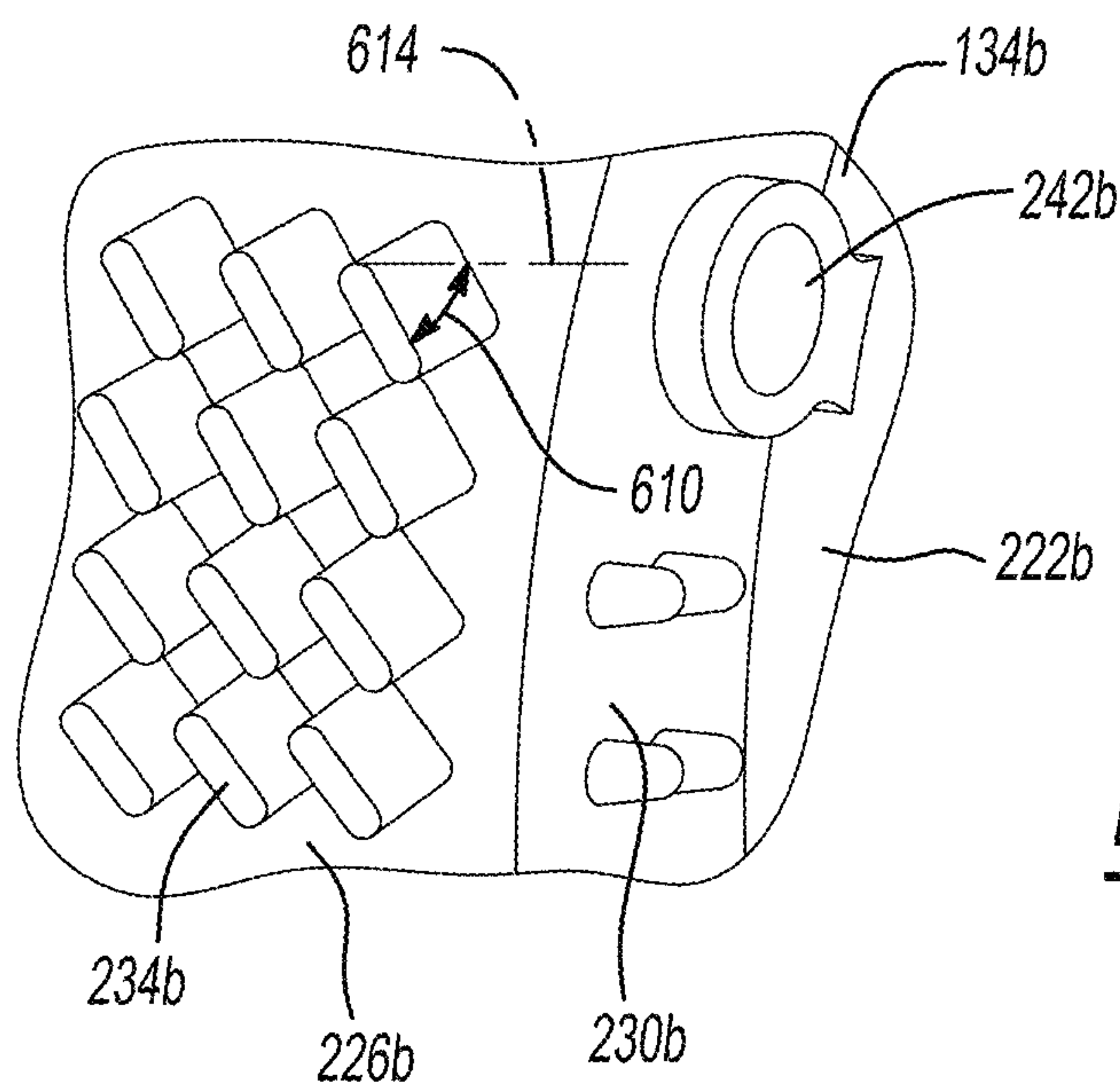


Fig-6

ELECTRIC MOTOR AND STATOR COOLING APPARATUS

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a continuation of U.S. application Ser. No. 17/128,281 filed Dec. 21, 2020, which is a continuation of U.S. application Ser. No. 15/820,934 filed Nov. 22, 2017 (now U.S. Pat. No. 10,879,749 issued Dec. 29, 2020). The disclosure of each of the above-referenced applications is incorporated by reference as if fully set forth in detail herein.

FIELD

The present disclosure relates to an electric motor and a stator cooling apparatus for an electric motor.

BACKGROUND

Electric motors, such as those used in vehicle drivelines, can generate heat during operation. Excess temperatures can have undesirable effects on performance and longevity of the electric motor and its associated components. As such, it can be advantageous to provide cooling to the motor to remove excess heat therefrom. While typical motor cooling methods can be sufficient for their intended uses, there continues to be a need for improved cooling of electric motors.

SUMMARY

This section provides a general summary of the disclosure and is not a comprehensive disclosure of its full scope or all of its features.

In one form, the present disclosure provides an electric motor can include a stator body, a rotor, a plurality of electrically conductive windings, a first end cap, and a second end cap. The stator body can be disposed about an axis and can define a plurality of fluid channels. The fluid channels can extend axially through the stator body to provide fluid communication between a first axial end of the stator body and a second axial end of the stator body. The rotor can be disposed about the axis and rotatable relative to the stator body. The plurality of electrically conductive windings can form a plurality of first winding loops and a plurality of second winding loops. The first winding loops can extend axially outward from the first axial end of the stator body. The second winding loops can extend axially outward from the second axial end of the stator body. The first end cap can be coupled to the first axial end of the stator body. The first end cap can include a first wall and a plurality of first pins. The first wall can be disposed between the first winding loops and the fluid channels. The first pins can extend from a side of the first wall that is opposite the first winding loops. The second end cap can be coupled to the second axial end of the stator body. The second end cap can include a second wall and a plurality of second pins. The second wall can be disposed between the second winding loops and the fluid channels. The second pins can extend from a side of the second wall that is opposite the second winding loops.

According to a further embodiment, the electric motor can further include a housing disposed about the stator body. The housing can cooperate with the stator body and the first end cap to define a first chamber in fluid communication with the fluid channels. The first pins can extend into the first

chamber. The housing can cooperate with the stator body and the second end cap to define a second chamber in fluid communication with the fluid channels. The second pins can extend into the second chamber.

According to a further embodiment, the electric motor can further include a pump including an inlet and outlet. The inlet of the pump can be in fluid communication with the second chamber to receive fluid therefrom. The outlet of the pump can be in fluid communication with the first chamber to pump fluid thereto.

According to a further embodiment, the electric motor can further include a at least one shroud that includes at least one of: a first shroud disposed about the axis between the first end cap and the housing and configured to guide fluid flow from the first chamber across the first pins to the fluid channels; or a second shroud disposed about the axis between the second end cap and the housing and configured to guide fluid flow from the fluid channels across the second pins to the second chamber.

According to a further embodiment, the first pins can extend radially outward from the first wall.

According to a further embodiment, the first pins can extend radially outward of a radially inward-most part of the fluid channels.

According to a further embodiment, the second pins can extend radially outward from the second wall.

According to a further embodiment, the second pins can extend radially outward of a radially inward-most part of the fluid channels.

According to a further embodiment, the electric motor can further include a sensor and at least one of the first end cap or the second end cap can define a sensor bore. The sensor can be removably disposed within the sensor bore and configured to output a signal that corresponds to a temperature of the electrically conducting windings.

According to a further embodiment, the first and second winding loops can be encased in a thermally conductive but electrically insulating resin that contacts the first and second walls and the first and second winding loops.

According to a further embodiment, the first and second winding loops can extend radially outward of a radially inward-most part of the fluid channels.

According to a further embodiment, the first wall can include a first annular body and a second annular body coupled to the first annular body to define a first winding cavity. The first winding loops can be disposed within the first winding cavity. The first pins can extend axially from at least one of: the first annular body in a direction toward the stator body, or the second annular body in a direction away from the stator body.

According to a further embodiment, the first pins can extend axially in the direction toward the stator body from the first annular body and axially in the direction away from the stator body from the second annular body.

According to a further embodiment, the second wall can include a third annular body and a fourth annular body coupled to the third annular body to define a second winding cavity. The second winding loops can be disposed within the second winding cavity. The second pins can extend axially from at least one of: the third annular body in a direction toward the stator body, or the second annular body in a direction away from the stator body.

According to a further embodiment, the second pins can extend axially in the direction toward the stator body from the third annular body and axially in the direction away from the stator body from the fourth annular body.

In another form, the present disclosure provides an electric motor including a housing, a stator body, a rotor, a plurality of electrically conductive windings, a first end cap, and a second end cap. The stator body can be disposed about an axis. The stator body can define a plurality of fluid channels that extend axially through the stator body to provide fluid communication between a first axial end of the stator body and a second axial end of the stator body. The rotor can be disposed about the axis and rotatable relative to the stator body. The plurality of electrically conductive windings can form a plurality of first winding loops and a plurality of second winding loops. The first winding loops can extend axially outward from the first axial end of the stator body. The second winding loops can extend axially outward from the second axial end of the stator body. The first end cap can be coupled to the first axial end of the stator body. The first end cap can include a first wall and a plurality of first pins. The first end cap and the housing can define a first fluid cavity in fluid communication with the fluid channels. The first end cap can define a first winding cavity separated from the first fluid cavity by the first wall. The first winding loops can be disposed within the first winding cavity. The first pins can extend from the first wall into the first fluid cavity. The second end cap can be coupled to the second axial end of the stator body. The second end cap can include a second wall and a plurality of second pins. The second end cap and the housing can define a second fluid cavity in fluid communication with the fluid channels. The second end cap can define a second winding cavity separated from the second fluid cavity by the second wall. The second winding loops can be disposed within the second winding cavity. The second pins can extend from the second wall into the second fluid cavity.

According to a further embodiment, the first pins can extend radially outward from the first wall and the second pins can extend radially outward from the second wall.

According to a further embodiment, the first and second pins can extend radially outward of a radially inward-most part of the fluid channels.

According to a further embodiment, the first and second winding loops can be encased in a thermally conductive but electrically insulating resin that contacts the first and second walls and the first and second winding loops.

According to a further embodiment, the first and second winding loops can extend radially outward of a radially inward-most part of the fluid channels.

According to a further embodiment, the first wall can include a first annular body and a second annular body coupled to the first annular body to define the first winding cavity. The first pins can extend axially from at least one of: the first annular body in a direction toward the stator body, or the second annular body in a direction away from the stator body. The second wall can include a third annular body and a fourth annular body coupled to the third annular body to define the second winding cavity. The second pins can extend axially from at least one of: the third annular body in a direction toward the stator body, or the second annular body in a direction away from the stator body.

Further areas of applicability will become apparent from the description provided herein. The description and specific examples in this summary are intended for purposes of illustration only and are not intended to limit the scope of the present disclosure.

DRAWINGS

The drawings described herein are for illustrative purposes only of selected embodiments and not all possible implementations and are not intended to limit the scope of the present disclosure.

FIG. 1 is a perspective view of a portion of an electric motor of a first construction, constructed in accordance with the teachings of the present disclosure;

FIG. 2 is a sectional view of a stator core of the electric motor of FIG. 1;

FIG. 3 is a schematic sectional view of a portion of the electric motor of FIG. 1, schematically illustrating a cooling circuit for cooling the electric motor;

FIG. 4 is a perspective view of a portion of an electric motor of a second construction, constructed in accordance with the teachings of the present disclosure;

FIG. 5 is a schematic sectional view of a portion of the electric motor of FIG. 4, schematically illustrating a cooling circuit for cooling the electric motor; and

FIG. 6 is a perspective view of a portion of an electric motor of a third construction.

Corresponding reference numerals indicate corresponding parts throughout the several views of the drawings.

DETAILED DESCRIPTION

With reference to FIGS. 1-3, an electric motor 110 of a first construction is illustrated. The electric motor 110 can include a housing 114, a stator 118, a rotor 122, an output shaft 126, a first end cap 130, a first shroud 132, a second end cap 134, a second shroud 136, and a cooling system 138. In the example provided, the housing 114 can define a generally cylindrical cavity 142 disposed about an axis 146. The stator 118 can be disposed about the axis 146 within the cylindrical cavity 142 and can be fixedly coupled to the housing 114 such that the stator 118 is non-rotatable relative to the housing 114. In the example provided, an outermost cylindrical surface of the stator 118 can include one or more grooves 150 that can extend axially along the stator 118 and can mate with a spline (not specifically shown) on an interior surface of the housing 114, though other configurations can be used. The stator 118 can be formed of a plurality of stator laminations stacked axially end to end along the axis 146, though other configurations can be used.

The stator 118 can be generally annular in shape, with a first axial face or end 154 and a second axial face or end 158 opposite the first axial end 154. The stator 118 can include an annular body 162, a plurality of winding poles 166, and a plurality of wire windings 170. The annular body 162 can be fixedly coupled to the winding poles 166 to make up the stator core. The annular body 162 can define a plurality of fluid channels 174 that can be open at the first axial end 154 and the second axial end 158 and can extend axially therebetween to permit fluid communication between the first axial end 154 and the second axial end 158. The fluid channels 174 can be disposed about the axis 146. In the example provided, the fluid channels 174 are equally spaced apart in the circumferential direction about the axis 146.

The winding poles 166 can extend radially inward from the radially inward side of the annular body 162. The winding poles 166 can be equally spaced apart in the circumferential direction about the axis 146 to define winding slots 178 between adjacent ones of the winding poles 166. Thus, the winding poles 166 and winding slots 178 can be radially inward of the fluid channels 174. Electrically conductive wire can extend through the winding slots 178 and be wound about the winding poles 166 to form the wire windings 170 in a manner such that a first section of the wire windings 170 forms first winding loops 182 that extend axially outward from the first axial end 154 of the stator 118 and a second section of the wire windings 170 forms second

winding loops **186** that extend axially outward from the second axial end **158** of the stator **118**.

The rotor **122** can be disposed about the axis **146** and can be supported for rotation relative to the stator **118**. The stator **118** can be disposed about the rotor **122** such that the rotor **122** is radially inward of the winding poles **166**. The output shaft **126** can be disposed about the axis **146** and fixedly coupled to the rotor **122** for common rotation about the axis **146**. In the example provided, the output shaft **126** can extend axially from both axial ends of the rotor **122**. While not specifically shown, the output shaft **126** can be coupled to a driveline of a vehicle for providing torque to a set of vehicle wheels.

The first end cap **130** can be a generally annular body and can include a first inner wall **190**, a first outer wall **194**, a first end wall **198**, and a plurality of first fins or pins **202**. In the example provided, the first end cap **130** is unitarily formed from a thermally conductive, but electrically insulating material, such as by injection molding of a plastic for example. A proximal end of the first inner wall **190** can abut the first axial end **154** of the stator **118**. The first inner wall **190** can extend axially from the first axial end **154** of the stator **118** to a distal end of the first inner wall **190**. The first inner wall **190** can be coaxial with the axis **146**. An outward facing cylindrical side of the first inner wall **190** can be disposed radially inward of the first winding loops **182** and an inward facing cylindrical side of the first inner wall **190** can be radially outward of the rotor **122**.

The first inner wall **190** can define a pocket **200** configured to receive a temperature sensor **204**. In the example provided, the pocket **200** extends generally axially relative to the axis **146** and is open facing axially away from the first axial end **154**. The pocket **200** can be radially inward of the first winding loops **182** and can extend axially toward the first axial end **154** such that the temperature sensor **204** therein can be in close proximity to the first winding loops **182**. For example, the temperature sensor **204** can axially overlap with the first winding loops **182**. In the example provided, the temperature sensor **204** is a thermistor, though other types of sensors can be used. Thus, pocket **200** and temperature sensor **204** can be located at a back (e.g., radially inner) plane of the first winding loops **182** such that they are away from the cooling flow, but in strong thermal conduction with the first winding loops **182** to provide accurate temperature readings of the first winding loops **182**. The temperature sensor **204** can be removably coupled to the pocket **200**, such as being threaded into the pocket **200** for example.

A proximal end of the first outer wall **194** can abut the first axial end **154** of the stator **118**. The first outer wall **194** can extend axially from the first axial end **154** of the stator **118** to a distal end of the first outer wall **194**. The first outer wall **194** can be coaxial with the axis **146**. In the example provided, the first outer wall **194** can be generally parallel to the first inner wall **190**. An outward facing cylindrical side of the first outer wall **194** can be disposed radially inward of the fluid channels **174** and an inward facing cylindrical side of the first outer wall **194** can be disposed radially outward of the first winding loops **182**.

The first end wall **198** can extend generally radially between the distal end of the first outer wall **194** and the first inner wall **190**. In the example provided, the first end wall **198** connects the distal end of the first outer wall **194** to the first inner wall **190** at a location on the first inner wall **190** that is axially between the proximal and distal ends of the first inner wall **190**. In the example provided, the first end wall **198** can be generally perpendicular to the axis **146**,

though other configurations can be used. The first inner wall **190**, the first outer wall **194**, and the first end wall **198** can cooperate to define a first winding cavity **206** that is disposed annularly about the axis **146** and open toward the stator **118** and configured to receive the first winding loops **182** therein. As such, the first winding cavity **206** can be open to the slots **178** of the stator **118**. In the example provided, the first end wall **198** can include one or more first ports **210** that can be open axially through the first end wall **198**.

A proximal end of each first pin **202** can be fixedly coupled to the first outer wall **194** and each first pin **202** can extend radially outward from the first outer wall **194** to a distal end. In the example provided, the distal ends of the first pins **202** can be radially outward of a radially innermost part of the openings of the fluid channels **174**. In the example provided, the first pins **202** can be equally spaced in the circumferential direction about the first outer wall **194**, though other configurations can be used. In the example provided, the first outer wall **194** includes six equally spaced rows of the first pins **202** in the axial direction, though more or fewer rows can be used, or the first pins can be such that they are not arranged in ordered rows. In the example provided, some of the first pins **202** also extend axially outward (i.e., the direction away from the stator **118**) from the first end wall **198**. In the example provided, the first pins **202** are generally cylindrical or conical in shape, but other configurations can be used, such as fins, ribs, blades, tabs, or pyramid-shapes for example.

The first axial end **154** of the stator **118**, the inner surface of the housing **114**, and the first outer wall **194** can cooperate to define a first chamber or fluid cavity **214** in fluid communication with the fluid channels **174**. In the example provided, the first chamber **214** is also defined by the first end wall **198** and the portion of the first inner wall **190** that is axially outward of the first end wall **198**, though other configurations can be used. Thus, the first pins **202** can extend within the first chamber **214**. In the example provided, the housing **114** defines an inlet port **218** in fluid communication with the first chamber **214**.

The first shroud **132** can be a hollow, generally cylindrical body disposed about the axis **146** and open at both axial ends of the first shroud **132**. The first shroud **132** can be fixedly coupled to the stator **118** or the housing **114**. The first shroud **132** can be generally between the first end cap **130** and the housing **114** to divide the first chamber **214** into an outer region and an inner region. The inner region can be open to the fluid channels **174**, i.e., in direct fluid communication with the fluid channels **174**. In other words, fluid flowing from the outer region to the fluid channels **174** must pass through the inner region. A radially inward surface of the first shroud **132** can be in close proximity to the distal ends of the first pins **202** such that fluid flowing through the inner region to the fluid channels **174** is guided across the first pins **202** and maintains a high velocity while passing between the first pins **202**.

The second end cap **134** can be similar to the first end cap **130** except as otherwise shown or described herein. The second end cap **134** can be a generally annular body and can include a second inner wall **222**, a second outer wall **226**, a second end wall **230**, and a plurality of second fins or pins **234**. In the example provided, the second end cap **134** is unitarily formed from a thermally conductive, but electrically insulating material, such as by injection molding of a plastic for example. A proximal end of the second inner wall **222** can abut the second axial end **158** of the stator **118**. The second inner wall **222** can extend axially from the second axial end **158** of the stator **118** to a distal end of the second

inner wall **222**. The second inner wall **222** can be coaxial with the axis **146**. An outward facing cylindrical side of the second inner wall **222** can be disposed radially inward of the second winding loops **186** and an inward facing cylindrical side of the second inner wall **222** can be radially outward of the rotor **122**.

The second inner wall **222** can optionally define a second pocket **232** configured to receive a second temperature sensor **236**. The second pocket **232** and second temperature sensor **236** can be similar to the pocket **200** and temperature sensor **204** except as otherwise shown or described herein. In the example provided, the second pocket **232** extends generally axially relative to the axis **146** and is open facing axially away from the second axial end **158**. The second pocket **232** can be radially inward of the second winding loops **186** and can extend axially toward the second axial end **158** such that the second temperature sensor **236** therein can be in close proximity to the second winding loops **186**. For example, the second temperature sensor **236** can axially overlap with the second winding loops **186**. In the example provided, the second temperature sensor **236** is a thermistor, though other types of sensors can be used. Thus, second pocket **232** and second temperature sensor **236** can be located at a back (e.g., radially inner) plane of the second winding loops **186** such that they are away from the cooling flow, but in strong thermal conduction with the second winding loops **186** to provide accurate temperature readings of the second winding loops **186**. The second temperature sensor **236** can be removably coupled to the second pocket **232**, such as being threaded into the second pocket **232** for example.

A proximal end of the second outer wall **226** can abut the second axial end **158** of the stator **118**. The second outer wall **226** can extend axially from the second axial end **158** of the stator **118** to a distal end of the second outer wall **226**. The second outer wall **226** can be coaxial with the axis **146**. In the example provided, the second outer wall **226** can be generally parallel to the second inner wall **222**. An outward facing cylindrical side of the second outer wall **226** can be disposed radially inward of the fluid channels **174** and an inward facing cylindrical side of the second outer wall **226** can be disposed radially outward of the second winding loops **186**.

The second end wall **230** can extend generally radially between the distal end of the second outer wall **226** and the second inner wall **222**. In the example provided, the second end wall **230** connects the distal end of the second outer wall **226** to the second inner wall **222** at a location on the second inner wall **222** that is axially between the proximal and distal ends of the second inner wall **222**. In the example provided, the second end wall **230** can be generally perpendicular to the axis **146**, though other configurations can be used. The second inner wall **222**, the second outer wall **226**, and the second end wall **230** can cooperate to define a second winding cavity **238** that is disposed annularly about the axis **146** and open toward the stator **118** and configured to receive the second winding loops **186** therein. As such, the second winding cavity **238** can be open to the slots **178** of the stator **118**. In the example provided, the second end wall **230** can include one or more second ports **242** that can be open axially through the second end wall **230**.

A proximal end of each second pin **234** can be fixedly coupled to the second outer wall **226** and each second pin **234** can extend radially outward from the second outer wall **226** to a distal end. In the example provided, the distal ends of the second pins **234** can be radially outward of a radially innermost part of the openings of the fluid channels **174**. In

the example provided, the second pins **234** can be equally spaced in the circumferential direction about the second outer wall **226**, though other configurations can be used. In the example provided, the second outer wall **226** includes six equally spaced rows of the second pins **234** in the axial direction, though more or fewer rows can be used, or the second pins can be such that they are not arranged in ordered rows. In the example provided, some of the second pins **234** also extend axially outward (i.e., the direction away from the stator **118**) from the second end wall **230**. In the example provided, the second pins **234** are generally cylindrical or conical in shape, but other configurations can be used, such as fins, ribs, blades, tabs, or pyramid-shapes for example.

With additional reference to FIG. 6, a portion of a second end cap **134b** is illustrated with one example of such a different configuration of the second pins **234b**. The second end cap **134b** and second pins **234b** can be similar to the second pins **234** (FIGS. 1 and 3), except as otherwise shown or described herein. Elements of the second end cap **134b** that are similar to elements of the second end cap **134** (FIGS. 1 and 3) are indicated with similar reference numerals followed by the numeral 'b' and only differences are described in detail herein. In the example shown, the second pins **234b** have a fin, rib, or blade type shape that are angled to promote uniform rotational flow around the second outer wall **226b**. In the example provided, the second pins **234b** can extend longitudinally at an angle **610** relative to the axis **146** (e.g., relative to line **614** which is parallel to the axis **146** shown in FIG. 3). This rotational flow around the second outer wall **226b** can promote uniform flow to the outlet port **250** (FIG. 3) and can increase heat absorption by the fluid. In the example provided, only the second pins **234b** have the angled, fin/rib/blade type of pin. In an alternative configuration, not specifically shown, the first end cap **130** (FIGS. 1 and 3) and not the second end cap **134** (FIGS. 1 and 3) can have such angled pins to promote rotational flow. In another alternative configuration, not specifically shown, both the first end cap **130** (FIGS. 1 and 3) and the second end cap **134b** can have such angled pins to promote rotational flow.

Returning to the example shown in FIGS. 1-3, the second axial end **158** of the stator **118**, the inner surface of the housing **114**, and the second outer wall **226** can cooperate to define a second chamber or fluid cavity **246** in fluid communication with the fluid channels **174**. In the example provided, the second chamber **246** is also defined by the second end wall **230** and the portion of the second inner wall **222** that is axially outward of the second end wall **230**, though other configurations can be used. Thus, the second pins **234** can extend within the second chamber **246**. In the example provided, the housing **114** defines an outlet port **250** in fluid communication with the second chamber **246**.

The second shroud **136** can be similar to the first shroud **132**, except as otherwise shown or described herein. The second shroud **136** can be a hollow, generally cylindrical body disposed about the axis **146** and open at both axial ends of the second shroud **136**. The second shroud **136** can be fixedly coupled to the stator **118** or the housing **114**. The second shroud **136** can be generally between the second end cap **230** and the housing **114** to divide the second chamber **246** into an outer region and an inner region. The inner region can be open to the fluid channels **174**, i.e., in direct fluid communication with the fluid channels **174**. In other words, fluid flowing from the fluid channels **174** to the outer region must pass through the inner region. A radially inward surface of the second shroud **136** can be in close proximity to the distal ends of the second pins **234** such that fluid flowing through the inner region from the fluid channels **174**

is guided across the second pins 234 and maintains a high velocity while passing between the second pins 234.

During assembly of the motor 110, the first end cap 130 can be fixedly mounted to the first axial end 154 of the stator 118 and the second end cap 134 can be fixedly mounted to the second axial end 158 of the stator 118. The slots 178, the first winding cavity 206, and the second winding cavity 238 can then be filled with a thermally conductive, but electrically insulating resin. For example, the resin may be pumped into the first winding cavity 206 via the first ports 210 until the resin fills the first winding cavity 206, the slots 178, and the second winding cavity 238. The resin may then be allowed to harden such that the hardened resin encapsulates the first winding loops 182 and the second winding loops 186, and also contacts the first end cap 130 and the second end cap 134.

Alternatively, the motor 110 may be positioned such that the axis 146 extends in a vertical direction relative to the ground and the first axial end 154 is facing upwards. In this vertical position of the motor 110, the second ports 242 can be sealed and resin may be poured in from the top through the first ports 210 until the resin fills the second winding cavity 238, the slots 178, and the first winding cavity 206. Alternatively, the second ports 242 can be open such that the resin can be pumped in from the bottom through the second ports 242 until the resin fills the second winding cavity 238, the slots 178, and the first winding cavity 206.

The cooling system 138 can include a pump 254 and a heat exchanger 258. The pump 254 can have an outlet coupled to the inlet port 218 for fluid communication therewith such that the pump 254 can pump fluid (e.g., dielectric cooling fluid) to the inlet port 218. The pump 254 can have an inlet coupled to an outlet of the heat exchanger 258 for fluid communication therewith to receive fluid from the heat exchanger 258. The heat exchanger 258 can be any suitable type of heat exchanger configured to release heat 262 to a heat sink (e.g., the atmosphere). The inlet of the heat exchanger 258 can be coupled to the outlet port 250 of the housing 114 to receive fluid therefrom. In an alternative configuration, not specifically shown, the heat exchanger 258 can be in-line between the pump 254 and the inlet port 218 (e.g., the inlet of the heat exchanger 258 can be coupled to the outlet of the pump 254, the outlet of the heat exchanger 258 can be coupled to the inlet port 218, and the inlet of the pump 254 can be coupled to the outlet port 250).

Thus, in operation, the pump 254 can pump cooling fluid through the cooling circuit, such that the fluid flows from the inlet port 218, axially across the first end cap 130 and between the first pins 202 to absorb heat from the first winding loops 182 via the first pins 202. The fluid can then flow into and through the fluid channels 174 to absorb more heat from the stator 118. The fluid can then flow from the fluid channels 174 axially across the second end cap 134 and between the second pins 234 to absorb heat from the second winding loops 186 via the second pins 234. The fluid can then flow through the outlet port 250 to the heat exchanger, where the heat 262 can be transferred from the fluid to a heat sink (e.g., the atmosphere).

With additional reference to FIGS. 4-5, an electric motor 110' of a second construction is illustrated. The electric motor 110' can be similar to the electric motor 110 of FIGS. 1-3 except as otherwise shown or described herein. Elements shown or described herein with primed reference numerals can be similar to those shown and described above with reference to similar non-primed reference numerals except as otherwise shown or described herein. Accordingly, only differences will be described in detail herein. The

electric motor 110' can include a housing 114', a stator 118', a rotor 122', an output shaft 126', a first end cap 130', a second end cap 134' and a cooling system 138'. In the example provided, the housing 114' can define a generally cylindrical cavity 142' disposed about an axis 146'. The stator 118' can be disposed about the axis 146' within the cylindrical cavity 142' and can be fixedly coupled to the housing 114' such that the stator 118' is non-rotatable relative to the housing 114'. In the example provided, an outermost cylindrical surface of the stator 118' can include one or more grooves 150' that can extend axially along the stator 118' and can mate with a spline (not specifically shown) on an interior surface of the housing 114', though other configurations can be used. The stator 118' can be formed of a plurality of stator laminations stacked axially end to end along the axis 146', though other configurations can be used.

The stator 118' can be generally annular in shape, with a first axial end 154' and a second axial end 158' opposite the first axial end 154'. The stator 118' can include an annular body 162', a plurality of winding poles 166', and a plurality of wire windings 170'. The annular body 162' can define a plurality of fluid channels 174' that can be open at the first axial end 154' and the second axial end 158' and can extend axially therebetween to permit fluid communication between the first axial end 154' and the second axial end 158'. The fluid channels 174' can be disposed about the axis 146'. In the example provided, the fluid channels 174' are equally spaced apart in the circumferential direction about the axis 146'.

The winding poles 166' can extend radially inward from the radially inward side of the annular body 162'. The winding poles 166' can be equally spaced apart in the circumferential direction about the axis 146' to define winding slots 178' between adjacent ones of the winding poles 166'. Thus, the winding poles 166' and winding slots 178' can be radially inward of the fluid channels 174'. Electrically conductive wire can extend through the winding slots 178' and be wound about the winding poles 166' to form the wire windings 170' in a manner such that a first section of the wire windings 170' forms first winding loops 182' that are axially outward from the first axial end 154' of the stator 118' and a second section of the wire windings 170' forms second winding loops 186' that are axially outward from the second axial end 158' of the stator 118'.

The first winding loops 182' can have a bend such that the first winding loops 182' have a first portion that is proximate to the stator 118' and extends axially outward therefrom, and a second portion that extends radially outward from the first portion. The second portion of the first winding loops 182' can extend radially outward of a radially inward-most part of the fluid channels 174'. In the example provided, the second portion of the first winding loops 182' extends radially outward of a radially outward-most part of the fluid channels 174'.

The second winding loops 186' can have a bend such that the second winding loops 186' have a first portion that is proximate to the stator 118' and extends axially outward therefrom, and a second portion that extends radially outward from the first portion. The second portion of the second winding loops 186' can extend radially outward of a radially inward-most part of the fluid channels 174'. In the example provided, the second portion of the second winding loops 186' extends radially outward of a radially outward-most part of the fluid channels 174'.

The rotor 122' can be disposed about the axis 146' and can be supported for rotation relative to the stator 118'. The stator 118' can be disposed about the rotor 122' such that the

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rotor 122' is radially inward of the winding poles 166'. The output shaft 126' can be disposed about the axis 146' and fixedly coupled to the rotor 122' for common rotation about the axis 146'. In the example provided, the output shaft 126' can extend axially from both axial ends of the rotor 122'. While not specifically shown, the output shaft 126' can be coupled to a driveline of a vehicle for providing torque to a set of vehicle wheels.

The first end cap 130' can be a generally annular body and can include a first inner wall 410, a pair of first outer walls 414, 418, a pair of first end walls 422, 426, and a plurality of first fins or pins 430. In the example provided, the first end cap 130' is constructed of a unitarily formed first body 434 and a separate, unitarily formed second body 438 that is fixedly coupled to the first body 434 such as by plastic welding for example. The first and second bodies 434, 438 of the first end cap 130' can be formed by any suitable means, such as by injection molding of a plastic for example. The first end cap 130' can be formed from a thermally conductive, but electrically insulating material.

A proximal end of the first inner wall 410 can abut the first axial end 154' of the stator 118'. The first inner wall 410 can extend generally axially from the first axial end 154' of the stator 118' to a distal end of the first inner wall 410. The first inner wall 410 can be coaxial with the axis 146', radially inward of the first winding loops 182' and radially outward of the rotor 122'. A proximal end of the first outer wall 414 can abut the first axial end 154' of the stator 118'. The first outer wall 414 can extend generally axially from the first axial end 154' of the stator 118' to a distal end of the first outer wall 414. The first outer wall 414 can be coaxial with the axis 146', radially outward of the first winding loops 182' and the slots 178', and radially inward of the fluid channels 174'. The distal end of the first outer wall 414 can be axially between the stator 118' and the distal end of the first inner wall 410.

The first end wall 422 can be annular in shape and can extend radially outward from the distal end of the first outer wall 414. In the example provided, the first end wall 422 can extend radially outward of the radially outward-most part of the fluid channels 174' and can extend radially outward of the radially outward-most cylindrical surface of the stator 118'. The first end wall 426 can be annular in shape and can extend radially outward from the first inner wall 410. In the example provided, the first end wall 426 is axially between the first end wall 422 and the distal end of the first inner wall 410 such that the first inner wall 410 extends axially outward of the first end wall 426. In the example provided, the first end wall 426 has an inner diameter that is greater than that of the first inner wall 410 and is fixedly coupled to the first inner wall 410 by a plurality of spokes 442 spaced circumferentially about the axis 146' and extending between the first inner wall 410 and the first end wall 426. The first end wall 426 can extend radially outward of the radially outward-most part of the fluid channels 174' and can extend radially outward of the radially outward-most cylindrical surface of the stator 118'. The first outer wall 418 can extend axially between the radially outward-most parts of the first end walls 422, 426. Accordingly, the first end walls 422, 426, the first inner wall 410, and the first outer walls 414, 418 can cooperate to define a first winding cavity 446 that is disposed annularly about the axis 146' and open toward the stator 118' and configured to receive the first winding loops 182' therein. As such, the first winding cavity 446 can be open to the slots 178' of the stator 118'.

A proximal end of each first pin 430 can be fixedly coupled to the first end wall 422 or the first end wall 426.

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Each first pin 430 coupled to the first end wall 422 can extend axially inward (i.e., toward the stator 118') from the first end wall 422 to a distal end. Each first pin 430 coupled to the first end wall 426 can extend axially outward (i.e., away from the stator 118') from the first end wall 426 to a distal end. In the example provided, the first pins 430 can be spaced apart to permit fluid to flow between the first pins 430. Thus, the first end cap 130' can have pins extending axially toward and away from the stator 118'. In the example provided, the first pins 430 are generally cylindrical or conical in shape, but other configurations can be used, such as fins, ribs, blades, tabs, or pyramid-shapes for example.

The first axial end 154' of the stator 118', the inner surface of the housing 114', the first outer walls 414, 418, and the first end walls 422, 426 can cooperate to define a first chamber or fluid cavity 214' in fluid communication with the fluid channels 174'. In the example provided, the first chamber 214' is also defined by the portion of the first inner wall 410 that is axially outward of the first end wall 426, though other configurations can be used. Thus, the first pins 430 can extend within the first chamber 214'. In the example provided, the housing 114' defines an inlet port 218' in fluid communication with the first chamber 214'.

The second end cap 134' can be similar to the first end cap 130' except as otherwise shown or described herein. The second end cap 134' can be a generally annular body and can include a second inner wall 450, a pair of second outer walls 454, 458, a pair of second end walls 462, 466, and a plurality of second fins or pins 470. In the example provided, the second end cap 134' is constructed of a unitarily formed third body 474 and a separate, unitarily formed fourth body 478 that is fixedly coupled to the third body 474 such as by plastic welding for example. The third and fourth bodies 474, 478 of the second end cap 134' can be formed by any suitable means, such as by injection molding of a plastic for example. The second end cap 134' can be formed from a thermally conductive, but electrically insulating material.

A proximal end of the second inner wall 450 can abut the second axial end 158' of the stator 118'. The second inner wall 450 can extend generally axially from the second axial end 158' of the stator 118' to a distal end of the second inner wall 450. The second inner wall 450 can be coaxial with the axis 146', radially inward of the second winding loops 186' and radially outward of the rotor 122'. A proximal end of the second outer wall 454 can abut the second axial end 158' of the stator 118'. The second outer wall 454 can extend generally axially from the second axial end 158' of the stator 118' to a distal end of the second outer wall 454. The second outer walls 454 can be coaxial with the axis 146', radially outward of the second winding loops 186' and the slots 178', and radially inward of the fluid channels 174'. The distal end of the second outer wall 454 can be axially between the stator 118' and the distal end of the second inner wall 450.

The second end wall 462 can be annular in shape and can extend radially outward from the distal end of the second outer wall 454. In the example provided, the second end wall 462 can extend radially outward of the radially outward-most part of the fluid channels 174' and can extend radially outward of the radially outward-most cylindrical surface of the stator 118'. The second end wall 466 can be annular in shape and can extend radially outward from the second inner wall 450. In the example provided, the second end wall 466 is axially between the second end wall 462 and the distal end of the second inner wall 450 such that the second inner wall 450 extends axially outward of the second end wall 466. In the example provided, the second end wall 466 has an inner diameter that is greater than that of the second inner wall 450.

and is fixedly coupled to the second inner wall 450 by a plurality of spokes 482 spaced circumferentially about the axis 146' and extending between the second inner wall 450 and the second end wall 466. The second end wall 466 can extend radially outward of the radially outward-most part of the fluid channels 174' and can extend radially outward of the radially outward-most cylindrical surface of the stator 118'. The second outer wall 458 can extend axially between the radially outward-most parts of the second end walls 462, 466. Accordingly, the second end walls 462, 466, the second inner wall 450, and the second outer walls 454, 458 can cooperate to define a second winding cavity 486 that is disposed annularly about the axis 146' and open toward the stator 118' and configured to receive the second winding loops 186' therein. As such, the second winding cavity 486 can be open to the slots 178' of the stator 118'.

A proximal end of each second pin 470 can be fixedly coupled to the second end wall 462 or the second end wall 466. Each second pin 470 coupled to the second end wall 462 can extend axially inward (i.e., toward the stator 118') from the second end wall 462 to a distal end. Each second pin 470 coupled to the second end wall 466 can extend axially outward (i.e., away from the stator 118') from the second end wall 466 to a distal end. In the example provided, the second pins 470 can be spaced apart to permit fluid to flow between the second pins 470. Thus, the second end cap 134' can have pins extending axially toward and away from the stator 118'. In the example provided, the second pins 470 are generally cylindrical or conical in shape, but other configurations can be used, such as fins, ribs, blades, tabs, or pyramid-shapes for example.

While not specifically shown, the first pins 430, and/or the second pins 470 can be constructed to promote uniform rotational flow of the fluid around the first and/or second end cap 130', 134', such as being fin, rib, or blade shaped and disposed at prescribed angles similar to those shown in FIG. 6.

Returning to the example provided in FIGS. 4 and 5, the second axial end 158' of the stator 118', the inner surface of the housing 114', the second outer walls 454, 458, and the second end walls 462, 466 can cooperate to define a second chamber or fluid cavity 246' in fluid communication with the fluid channels 174'. In the example provided, the second chamber 246' is also defined by the portion of the second inner wall 450 that is axially outward of the second end wall 466, though other configurations can be used. Thus, the second pins 470 can extend within the second chamber 246'. In the example provided, the housing 114' defines an outlet port 250' in fluid communication with the second chamber 246'.

During assembly of the motor 110', the first end cap 130' can be fixedly mounted to the first axial end 154' of the stator 118' and the second end cap 134' can be fixedly mounted to the second axial end 158' of the stator 118'. The slots 178', the first winding cavity 446, and the second winding cavity 486 can then be filled with a thermally conductive, but electrically insulating resin. For example, the resin may be pumped into the first winding cavity 446 via the gaps between the spokes 442 until the resin fills the first winding cavity 446, the slots 178', and the second winding cavity 486. The resin may then be allowed to harden such that the hardened resin encapsulates the first winding loops 182' and the second winding loops 186', and also contacts the first end cap 130' and the second end cap 134'.

Alternatively, the motor 110' may be positioned such that the axis 146' extends in a vertical direction relative to the ground and the first axial end 154' is facing upwards. In this

vertical position of the motor 110', the gaps between the spokes 482 can be sealed and resin may be poured in from the top through the gaps between the spokes 442 until the resin fills the second winding cavity 486, the slots 178', and the first winding cavity 446. Alternatively, the gaps between the spokes 482 can be open such that the resin can be pumped in from the bottom through the gaps between the spokes 482 until the resin fills the second winding cavity 486, the slots 178', and the first winding cavity 446.

The cooling system 138' can include a pump 254' and a heat exchanger 258'. The pump 254' can have an outlet coupled to the inlet port 218' for fluid communication therewith such that the pump 254' can pump fluid (e.g., dielectric cooling fluid) to the inlet port 218'. The pump 254' can have an inlet coupled to an outlet of the heat exchanger 258' for fluid communication therewith to receive fluid from the heat exchanger 258'. The heat exchanger 258' can be any suitable type of heat exchanger configured to release heat 262' to a heat sink (e.g., the atmosphere). The inlet of the heat exchanger 258' can be coupled to the outlet port 250' of the housing 114' to receive fluid therefrom. In an alternative configuration, not specifically shown, the heat exchanger 258' can be in-line between the pump 254' and the inlet port 218' (e.g., the inlet of the heat exchanger 258' can be coupled to the outlet of the pump 254', the outlet of the heat exchanger 258' can be coupled to the inlet port 218', and the inlet of the pump 254' can be coupled to the outlet port 250').

Thus, in operation, the pump 254' can pump cooling fluid through the cooling circuit, such that the fluid flows from the inlet port 218', radially outward across the first end wall 426 and between the first pins 430 thereon to absorb heat from the first winding loops 182 via the first pins 430. The fluid can then flow axially around the first outer wall 418 and radially inward across the first end wall 422 and between the first pins 430 thereon to absorb more heat before entering the fluid channels 174'. The fluid can then flow through the fluid channels 174' to absorb more heat from the stator 118'. The fluid can then flow from the fluid channels 174' radially outward across the second end wall 462 and between the second pins 470 thereon to absorb more heat. The fluid can then flow axially around the second outer wall 458 and radially inward across the second end wall 466 and between the second pins 470 thereon to absorb more heat. The fluid can then flow through the outlet port 250' to the heat exchanger 258', where the heat 262' can be transferred from the fluid to a heat sink (e.g., the atmosphere).

The foregoing description of the embodiments has been provided for purposes of illustration and description. It is not intended to be exhaustive or to limit the disclosure. Individual elements or features of a particular embodiment are generally not limited to that particular embodiment, but, where applicable, are interchangeable and can be used in a selected embodiment, even if not specifically shown or described. The same may also be varied in many ways. Such variations are not to be regarded as a departure from the disclosure, and all such modifications are intended to be included within the scope of the disclosure.

What is claimed is:

1. An electric motor comprising:

- a stator body defining a rotor bore and a plurality of fluid channels;
- a plurality of electrically conductive windings forming a plurality of first winding loops extending axially outward from a first axial end of the stator body;
- a first end cap coupled to the first axial end of the stator body, the first end cap including a first wall and a plurality of first pins, the first wall disposed between

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the first winding loops and the fluid channels, the first pins extending from a side of the first wall that is opposite the first winding loops; and wherein the first pins extend radially outward from the first wall; and wherein the first pins extend radially outward of a radially inward-most part of the fluid channels.

2. The electric motor of claim 1, further comprising a second end cap, wherein the plurality of electrically conductive windings form a plurality of second winding loops extending axially outward from a second axial end of the stator body, wherein the second end cap is coupled to the second axial end of the stator body and includes a second wall and a plurality of second pins, the second wall being disposed between the second winding loops and the fluid channels, the second pins extending from a side of the second wall that is opposite the second winding loops, and wherein the second pins extend radially outward from the second wall and extend radially outward of a radially inward-most part of the fluid channels.

3. An electric motor comprising:

a stator body defining a rotor bore and a plurality of fluid channels;

a plurality of electrically conductive windings forming a plurality of first winding loops extending axially outward from a first axial end of the stator body;

a first end cap coupled to the first axial end of the stator body, the first end cap including a first wall and a plurality of first pins, the first wall disposed between the first winding loops and the fluid channels, the first pins extending from a side of the first wall that is opposite the first winding loops; and

wherein the first winding loops extend radially outward of a radially inward-most part of the fluid channels; and wherein the first wall includes a first annular body and wherein the first pins extend axially from the first annular body in a direction toward the stator body.

4. The electric motor of claim 3, wherein the first winding loops are encased in a thermally conductive but electrically insulating resin that contacts the first wall.

5. The electric motor of claim 3, wherein the first wall includes a second annular body and wherein the first pins extend axially from the second annular body in the direction away from the stator body.

6. The electric motor of claim 3, further comprising a second end cap coupled to a second axial end of the stator body, wherein the plurality of electrically conductive windings form a plurality of second winding loops that extend axially outward from the second axial end of the stator body, wherein the second end cap includes a second wall and a plurality of second pins, the second wall being disposed radially between the second winding loops and the fluid channels, the second pins extending from a side of the second wall that is opposite the second winding loops, the second pins extending into a flow path into or exiting the fluid channels in the stator body.

7. The electric motor of claim 6, wherein the second wall includes a third annular body, the second pins extending axially from the third annular body in a direction toward the stator body.

8. The electric motor of claim 7, wherein the second wall includes a fourth annular body, wherein the second pins extend axially from the fourth annular body in the direction away from the stator body.

9. The electric motor of claim 6, wherein the second wall includes a third annular body and a fourth annular body coupled to the third annular body to define a second winding

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cavity, the second winding loops being disposed within the second winding cavity, the second pins extending axially from the second annular body in a direction away from the stator body.

10. An electric motor comprising:

a stator body defining a rotor bore and a plurality of fluid channels;

a plurality of electrically conductive windings forming a plurality of first winding loops extending axially outward from a first axial end of the stator body;

a first end cap coupled to the first axial end of the stator body, the first end cap including a first wall and a plurality of first pins, the first wall disposed between the first winding loops and the fluid channels, the first pins extending from a side of the first wall that is opposite the first winding loops; and

wherein the first winding loops extend radially outward of a radially inward-most part of the fluid channels; and wherein the first wall includes a first annular body and a second annular body coupled to the first annular body to define a first winding cavity, the first winding loops being disposed within the first winding cavity.

11. The electric motor of claim 10, wherein the first winding loops are encased in a thermally conductive but electrically insulating resin that contacts the first wall.

12. The electric motor of claim 10, wherein the first pins extend axially in the direction toward the stator body from the first annular body, or the second annular body in a direction away from the stator body.

13. The electric motor of claim 10, further comprising a second end cap coupled to a second axial end of the stator body, wherein the plurality of electrically conductive windings form a plurality of second winding loops that extend axially outward from the second axial end of the stator body, wherein the second end cap includes a second wall and a plurality of second pins, the second wall being disposed in a radial direction from a central axis of the rotor bore between the second winding loops and the fluid channels, the second pins extending from a side of the second wall that is opposite the second winding loops, the second pins extending into a flow path into or exiting the fluid channels in the stator body.

14. The electric motor of claim 13, wherein the second wall includes a third annular body and a fourth annular body coupled to the third annular body to define a second winding cavity, the second winding loops being disposed within the second winding cavity.

15. The electric motor of claim 14, wherein the second pins extend axially in the direction toward the stator body from the third annular body and axially in the direction away from the stator body from the fourth annular body.

16. The electric motor of claim 15, wherein the second wall includes a third annular body and a fourth annular body coupled to the third annular body to define a second winding cavity, the second winding loops being disposed within the second winding cavity, the second pins extending axially from the second annular body in a direction away from the stator body.

17. An electric motor comprising:

a stator body defining a rotor bore and a plurality of fluid channels;

a plurality of electrically conductive windings forming a plurality of first winding loops extending axially outward from a first axial end of the stator body; and

a first end cap coupled to the first axial end of the stator body, the first end cap including a first wall, the first end cap defining a first winding cavity separated from fluid

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communication with the fluid channels by the first wall,
the first winding loops being disposed within the first
winding cavity;

wherein the first winding loops extend radially outward of
a radially inward-most part of the fluid channels. 5

18. The electric motor of claim **17**, wherein the first end
cap includes a plurality of first pins that extend radially
outward from the first wall.

19. The electric motor of claim **18**, wherein the first pins
extend radially outward of a radially inward-most part of the 10
fluid channels.

20. The electric motor of claim **17**, wherein the first end
cap includes a plurality of first pins that extend from the first
wall, wherein the first wall includes a first annular body and
a second annular body coupled to the first annular body to 15
define the first winding cavity, the first pins extending
axially from at least one of: the first annular body in a
direction toward the stator body, and the second annular
body in a direction away from the stator body.

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